



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5520-1

Job Sheet 179500



Part No: D5520-1

Job Qty: 20 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/19/18

Job Tracking No:

Due Date: 7/20/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG D5520 REV.A IPP REV:A 17.05.12 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Waterjet		SC R/DG/20
100	Waterjet	20 pcs	7/20/18	7/20/18	0.00	2.50	Waterjet1		SC R/DG/20
110	QC	20 pcs	7/20/18	7/20/18	0.00	0.00	QC2 Waterjet-4		SC R/DG/20
120	QC	20 pcs	7/20/18	7/20/18	0.00	0.00	QC8-6		38
130	Brake NC	20 pcs	7/20/18	7/20/18	0.00	1.33	Brake NC 1		DAS-SS SB
140	QC	20 pcs	7/20/18	7/20/18	0.00	0.00	QC5		38
150	HandFinish	20 pcs	7/20/18	7/20/18	0.00	1.00	HandFinish1		SA-88-07-09
160	QC	20 pcs	7/20/18	7/20/18	0.00	0.00	QC7-5		AS JUL 10 2018
170	SprayPaint	20 pcs	7/20/18	7/20/18	0.00	3.33	Spray Paint		AS JUL 10 2018
180	QC	20 pcs	7/20/18	7/20/18	0.00	0.00	QC3		38
190	Packaging	20 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-2		DAS-SS
200	QC21-SA	20 Ea	7/20/18	7/20/18	0.00	0.00	QC21		21 JUL 10 2018

Part Op 100 - 1-Cut as per Dwg ***VERIFY GRAIN DIRECTION*** Dwg Rev: A Prog Rev: A 2-Debur if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - FORM TO CORRECT RAD AS PER DWG "USE THE INSIDE EXTRUSION D2962 FOR FIT TEST"

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - QC7-Inspect Chemical Conversion Coat

170 - Prime as per Dart QSI 005 4.2 Primer Batch: 138862

180 - QC3- Inspect Part Finish

190 - Identify as per dwg & Stock Location:

200 - QC21- Final Inspection - Work Order Release

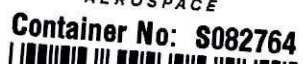
L6001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.188	6061-T6 .188 Sheet	3.3200 sf (.166 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.188	3	46	0



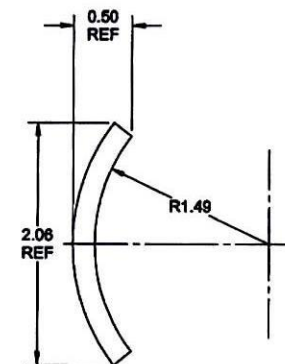
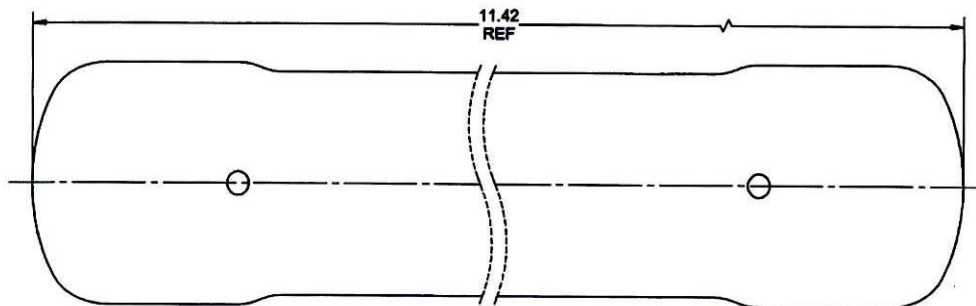
Part: D5520-1

Date: 06/20/18

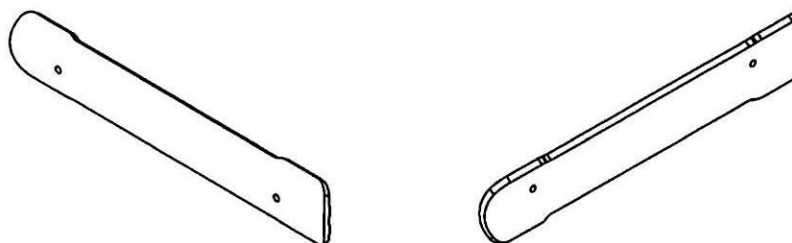
Part Specifications

Specifications could not be found.

Plex 6/19/18 3:42 PM dart.white.jesse



D5520-1 DOUBLER
(BEND DETAIL)



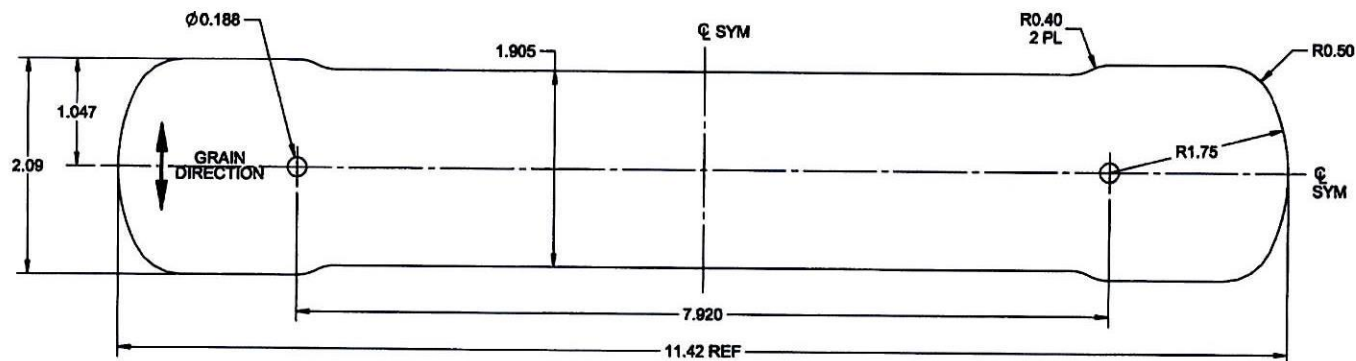
NOTES:

- 1) MATERIAL: MAKE FROM D5520-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

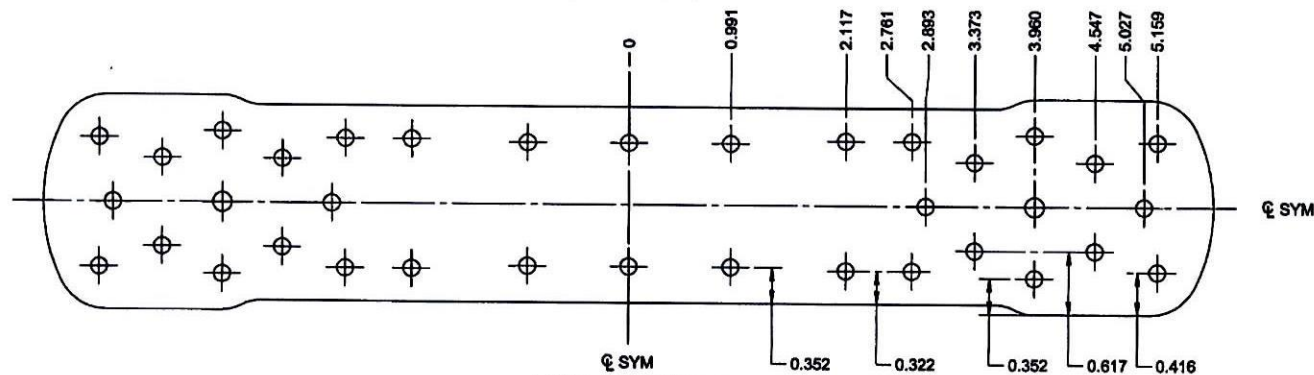
RELEASED
2017-08-11
EW 17-547

APPROVED

A	NEW ISSUE (NCR17-5303)	ML	17.03.09
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. A
MFG. APPR.	DP	D5520	SHEET 1 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
DATE	17.03.09	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D5520-1F DOUBLER
(FLAT PATTERN)



D5520-1F DOUBLER

+ REPRESENTS THE LOCATION OF RIVET HOLES
TO BE DRILLED ON INSTALLATION
(HOLES SHOWN AS REFERENCE ONLY)

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR/SHEET, 0.188 THICK
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221 OR QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6B0.188 OR M6061T6S0.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs
- 8) DRILL HOLES USING DT10309

RELEASED
2017-08-11

APPROVED

DESIGN	ML	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. A
MFG. APPR.	DP	D5520	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
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